

Date: Thursday, 17/07/2008 1:46:19 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE  
 Job Number : 40599  
 Estimate Number : 13469  
 P.O. Number : Part Number : PB6743001113  
 This Issue : 17/07/2008 S.O. No. : Drawing Number : B6743001 PAGE33  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : MACHINED PARTS Drawing Revision : B1  
 Previous Run : Material :  
 Written By : Due Date : 24/07/2008 Qty: 3 Um: Each  
 Checked & Approved By : mf 08-07-17  
 Comment : Est Rev:A 08-07-17 new issue DD verified by:EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W125	6061T6 SQ TUBE 1.00 x 1.00 x .125w

Comment: Qty.: 1.9425 f(s)/Unit Total: 9.7125 f(s)  
 6061T6 SQ TUBE 1.00 x 1.00 x .125w  
 batch: MD8626

J-F - 08/07/23 (5)

2.0	BAND SAW	BAND SAW
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Comment: Cut blank as per dwg PB67-43001

J-F 08/07/23 (5)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Mill as per Dwg B67-43001 (EXCEPT 1.75" DIA.)  
 Deburr

J-F. 08/07/23 (3)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F. 08/07/23 (3)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J-F 08/07/30 (3)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: WA

J-F 08/07/30 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-113 PAR #: N/A Fault Category: Prod / Machine / Part NCR: (Yes) No DQA: D Date: 08/05/08  
 QA: N/C Closed: D Date: 08/05/08

NCR: <u>40599</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/07/03</u>	<u>#3.0</u>	<u>Durrin conc. milling operator milled two parts incorrectly. one part 1/4" slot length 1.300 instead of 1.1".</u>	<u>[Signature]</u> <u>08.07.23</u>	<u>Scrap and Destroy</u> <u><del>and replace Qty 12</del></u> <u>No replace Qty 12</u>	<u>J.F.</u> <u>08/07/23</u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u> <u>08.07.23</u>	<u>[Signature]</u> <u>08/07/23</u>
		<u>-one part 1/4" slot 1.888 instead of 1.750".</u> <u>R.C. he got mixed up in</u>	<u>[Signature]</u> <u>08.07.23</u>	<u><del>No material</del></u>	<u>J.F.</u> <u>08/07/23</u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u> <u>08.07.23</u>	<u>[Signature]</u> <u>08/07/23</u>
		<u>He two different views.</u> <u>operator error</u>	<u>[Signature]</u> <u>08.07.23</u>		<u>J.F.</u> <u>08/07/23</u>	<u>[Signature]</u> <u>08/07/30</u>	<u>[Signature]</u> <u>08.07.23</u>	<u>[Signature]</u> <u>08/07/23</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 40599

Part Number: PB6743001113

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

③  
17/08/25/08

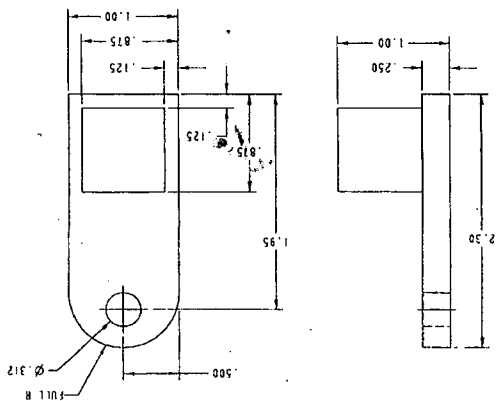
Job Completion



U 08.08.01

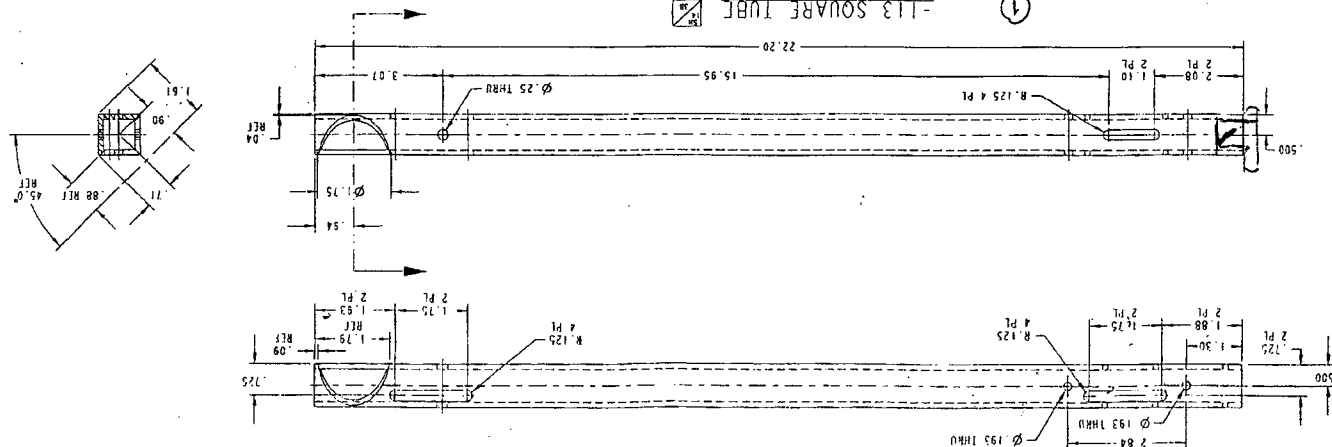
PREMIER AVIATION, INC.  
2000 Aviation Parkway, Grand Prairie, Texas 75050

① -119 END CAP CLEVIS



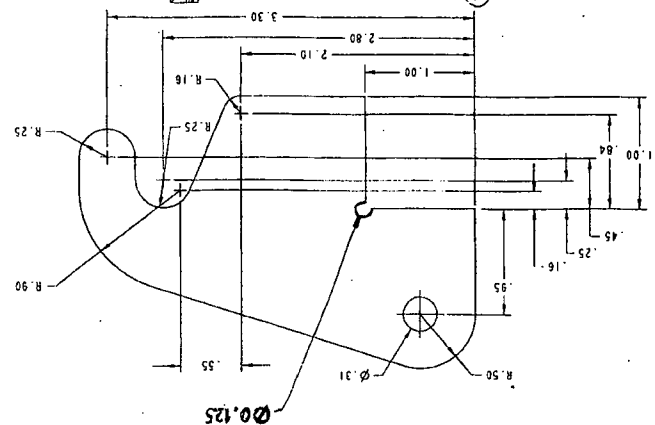
#40599

113 SQUARE TUBE  
MATERIAL: 1.00 SQ X .125 WALL, 6061-T6, 00-A-200/8  
SCALE: 0.750



RELEASED  
JUN 24 1964

117 HOOK PLATE  
MAY 16 25 THX. 6661-16, 00-A-250711  
SCALE 2.000



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40599
<b>Description:</b> Square Tube		<b>Part Number:</b> PB6743001113
<b>Inspection Dwg:</b> B67-43001 Rev: B1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00"	$\pm .010$ "	5.02"	✓			
7.25"	$\pm .010$ "	7.21"	✓			
1.30"	$\pm .030$ "	1.301"	✓			
1.88"	$\pm .030$ "	1.88"	✓			
2.84"	$\pm .030$ "	2.842"	✓			
1.75"	$\pm .030$ "	1.750"	✓			
Ø .193	$\pm .004$ "	Ø .194"	✓			
Slot .250"	$\pm .010$ "	.248"	✓			
1.930"	$\pm .030$ "	1.92"	✓			
Ø .250"	$\pm .001$ "	Ø .251"	✓			
2.08"	$\pm .030$ "	2.079"	✓			
1.10"	$\pm .030$ "	1.099"	✓			
3.07"	$\pm .030$ "	3.060"	✓			
22.20"	$\pm .030$ "	22.20"	✓			
5.00"	$\pm .010$ "	5.05"	✓			

<b>Measured by:</b> J.F.	<b>Audited by:</b> DIP	<b>Prototype Approval:</b>
<b>Date:</b> 08/07/23	<b>Date:</b> 08/07/30	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	